

Work Order ID 148965

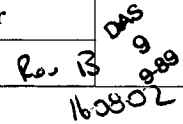
Tuesday, July 12, 2016 11:33:28 AM

~~*148965*~~ PRELIMINARY ISSUE

Page 1

Item ID: D3674-7 Accept *N900040100* Setup Start *NS1*
 Revision ID: PRELIM Stop *NS2*
 Item Name: Guide
 Start Date: 07/12/2016 Start Qty: 4.00 *4* Cust Item ID: 
 Required Date: 07/15/2016 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan  Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3674	Rev 13 								
100	BAND SAW	0.00				4	φ		DAS 08 9-89
100	Memo	0.01							
Bandsaw	Cut Blanks. Blank size: 1.250" x .750" x .950" long								
Jeaspa Bandsaw									
110	HAAS CNC VERTICAL MACHINING #1	0.28				4	φ		DAS 08 9-89
110	Memo	0.04							
HAAS 1	1-Machine as per Folio FB484								
HAAS CNC vertical machine #1	FOLIO REV: AA								
	DWG REV: B4								
	Deburr								

Work Order ID 148965***148965***

Page 2

Item ID: D3674-7

Accept

N900040100Setup Start ***NS1***

Revision ID: PRELIM

Stop ***NS2***

Item Name: Guide

Start Date: 07/12/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 07/15/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS
120						4	0		08
QC	Memo	0.01		16/07/16					9-89
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.01							
Quality Control									
140	Identify as per dwg & Stock Location <u>Set in</u>	0.00							
140									
Packaging	Memo	0.01							
Packaging									

DAS
6
9-89

AUG 02 2016

Work Order ID 148965

148965

Page 3

Tuesday, July 12, 2016 11:33:28 AM

Item ID: D3674-7 Accept *N900040100* Setup Start *NS1*
Revision ID: PRELIM Stop *NS2*
Item Name: Guide
Start Date: 07/12/2016 Start Qty: 4.00 *4* Cust Item ID:
Required Date: 07/15/2016 Req'd Qty: 4.00 *4* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00					DAS 21 9-89		AUG 0 2 2016
150									
QC	Memo	0.07							
Quality Control									

POSITIVE RECALL

EFFECTIVE 16-07-12 MTN
RELEASED 9 DATE 16-08-02
9-89

at Les B per ECN16-531

ENG 7105

DAS
21
9-89
JUL 18 2016
9107-8179f

Picklist Print

Tuesday, July 12, 2016 11:33:27 AM

Page 1

Work Order ID: 148965

148965

Parent Item: D3674-7

D3674-7

Parent Item Name: Guide

Start Date: 07/12/2016

Required Date: 07/15/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 16-07-12 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINB0.75X1.250		Purchased			No		f	30.1750		0.333053			
MDFI RINB0 75X1 250										**		B. 16/07/16	
Delrin Bar													

Location

Loc Qty

Loc Code

MAT039

30.175

m133818

3

➔ m134477

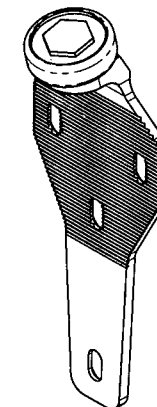
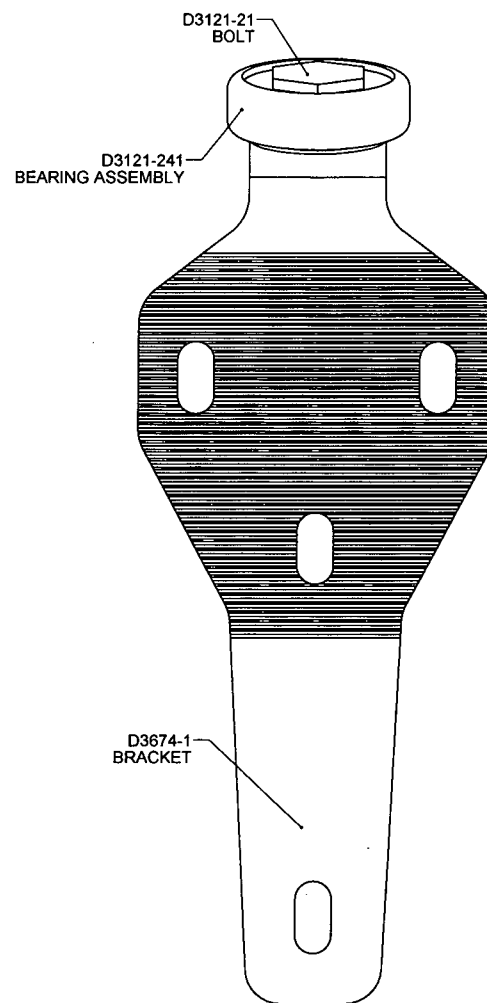
3.175

m134641

24

0.358 f+

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3674-041	ROLLER BRACKET ASSEMBLY
1	1	D3674-1	BRACKET
2	1	D3121-21	BOLT
3	1	D3121-241	BEARING ASSEMBLY

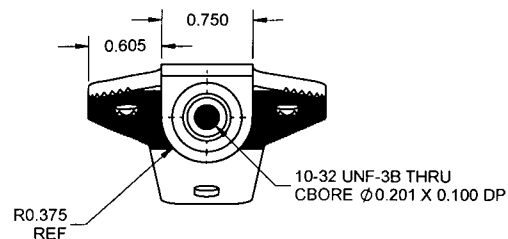


D3674-041 ROLLER BRACKET ASSEMBLY

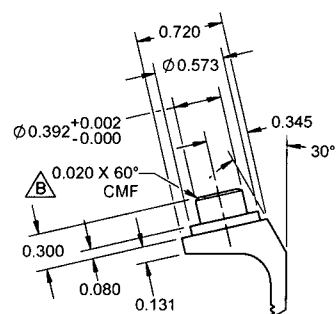
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.26 lbs
 - 8) TORQUE D3121-21 BOLT 15-25 in lbs (1.7-2.8 Nm)

PRELIMINARY ISSUE

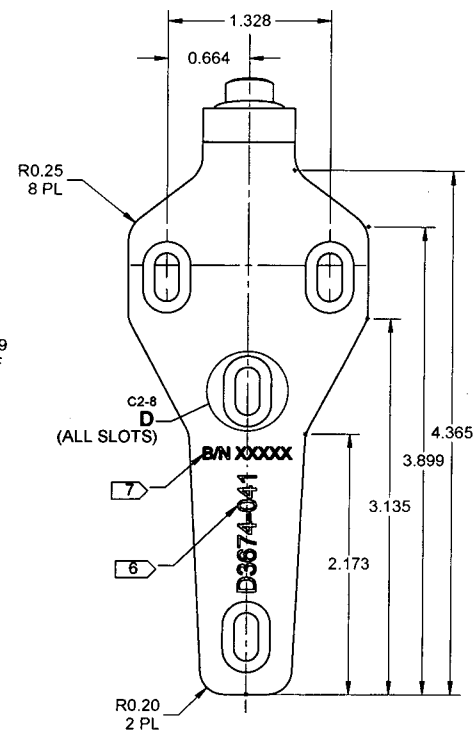
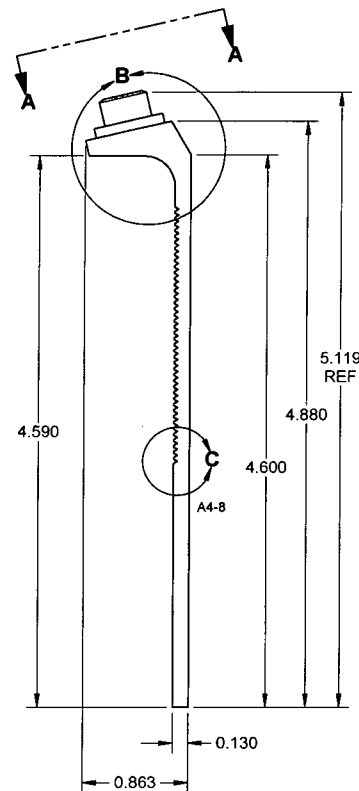
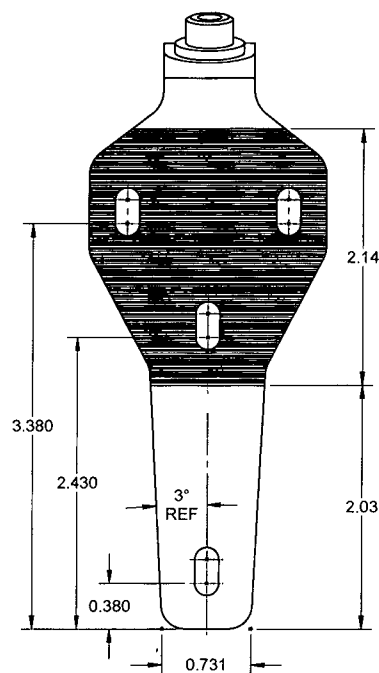
B	GENERAL UPDATE TO CURRENT STANDARDS. ADD -3/-5/-7/-9/-043/-044/-045. FOR BELL COMPOSITE DOOR SEE PAR 16-501. SHT 2 UPDATE NOTE 6.		AJS	16.06.01
A	NEW ISSUE		AJS	08.03.26
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED	MB	DRAWING NO.	REV. B	
MFG. APPR.	JLM	ROLLER BRACKET ASSEMBLY		SHEET 1 OF 8
APPROVED		TITLE		SCALE
DE APPR.		D3674		NTS
DATE	16.06.01			
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VIEW A-A



DETAIL B



D3674-1 BRACKET

NOTES:

- 1) MATERIAL: 17-4 PH, STAINLESS STEEL BAR
PER AMS 5604/5643
GRAIN DIRECTION MUST BE ALONG THE LENGTH OF THE BRACKET
MINIMUM YIELD TENSILE STRENGTH = 100 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 150 ksi
REF. DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3674-041" WITH 0.15 HIGH LETTERS TO A
MAX DEPTH OF 0.010 IN AREA SHOWN.
- 7) IDENTIFICATION: SCRIBE B/N PER QSI 044 6.4
- 8) WEIGHT: 0.22 lbs
- 9) BASIC PROFILE OF D3674-1 BRACKET TAKEN FROM D3121-141 REF.
- 10) ALL NON DIMENSIONED FEATURES PER CAD FILE "D3674-1RevB.STP/SLDPRT"

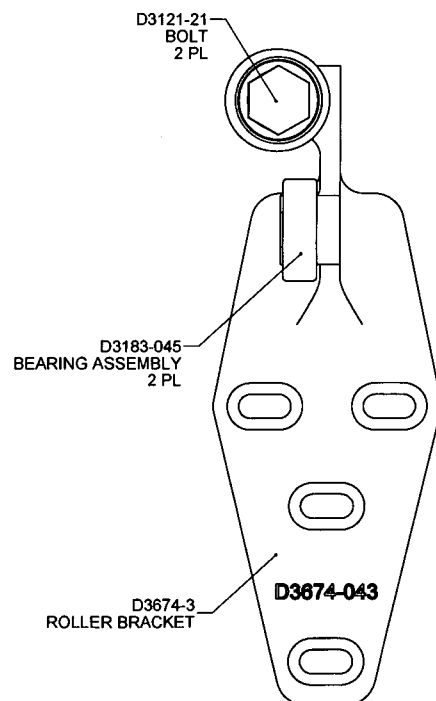
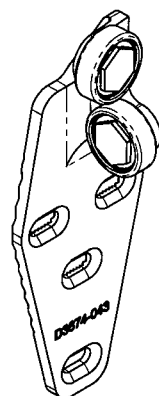
PRELIMINARY ISSUE

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DRAWN	AJS		
CHECKED	MB	DRAWING NO.	REV. B4
MFG. APPR.	JLM	ROLLER BRACKET ASSEMBLY	
APPROVED		TITLE	SCALE
DE APPR.		D3674	NTS
DATE	16.06.01	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

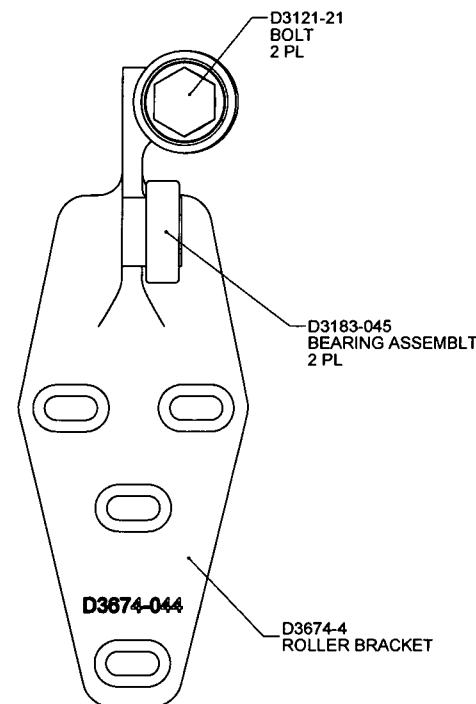
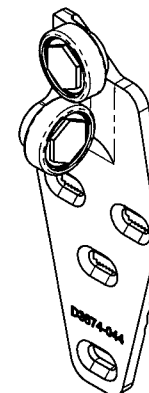
A

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3674-043	ROLLER BRACKET ASSEMBLY
1	1	D3674-3	ROLLER BRACKET
2	2	D3183-045	BEARING ASSEMBLY
3	2	D3121-21	BOLT

ITEM	QTY -044	P/N	DESCRIPTION
	X	D3674-044	ROLLER BRACKET ASSEMBLY
1	1	D3674-4	ROLLER BRACKET
2	2	D3183-045	BEARING ASSEMBLY
3	2	D3121-21	BOLT



D3674-043 ROLLER BRACKET ASSEMBLY



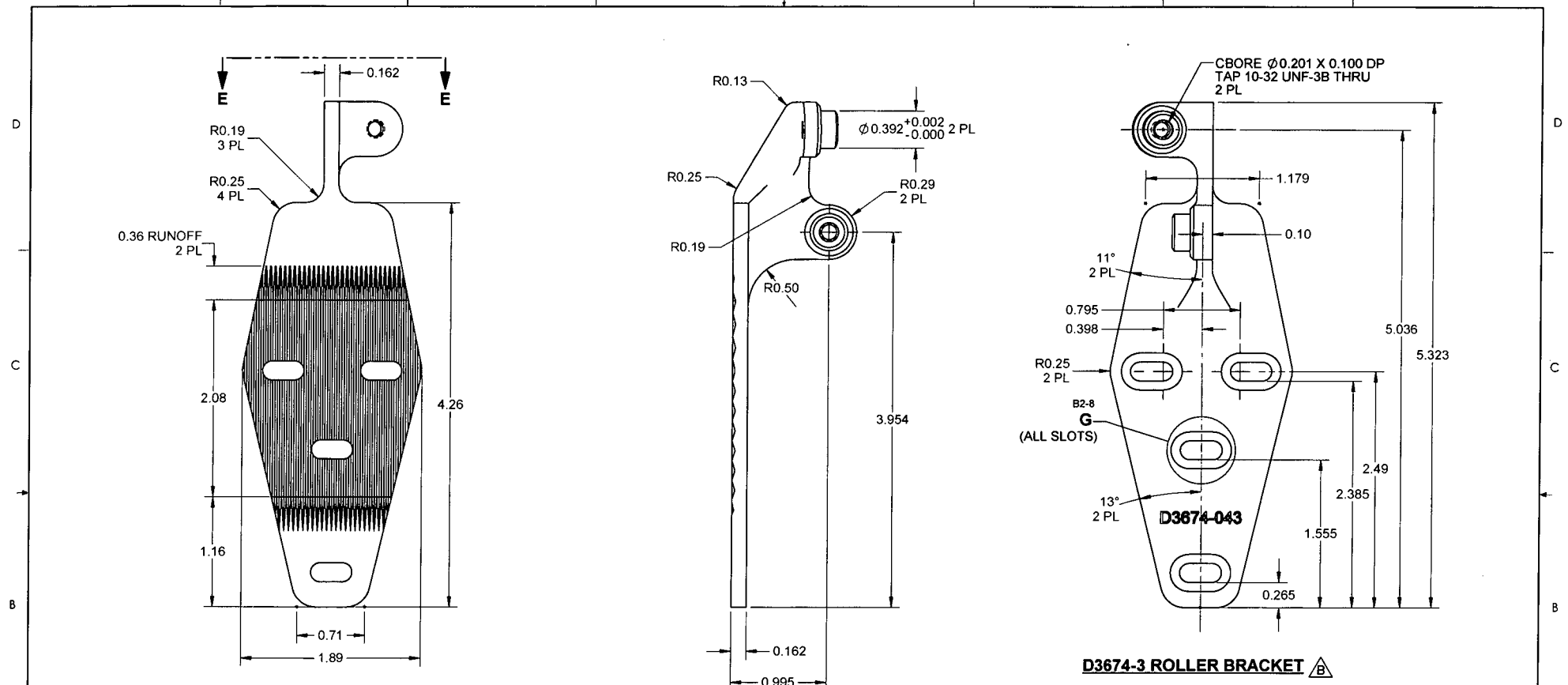
D3674-044 ROLLER BRACKET ASSEMBLY

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.37 lbs
 8) TORQUE D3121-21 BOLT 15-25 in lbs (1.7-2.8 Nm)

PRELIMINARY ISSUE

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	MB	DRAWING NO.	REV. B4
MFG. APPR.	JLM	ROLLER BRACKET ASSEMBLY	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		D3674	NTS
DATE	16.06.01	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

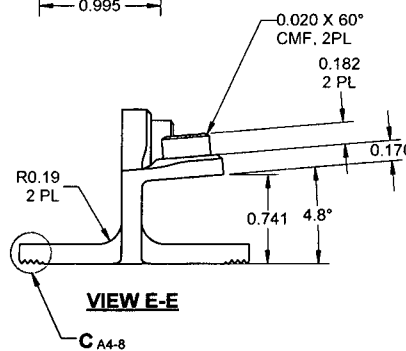
8 7 6 5 4 3 2 1



NOTES:

- 1) MATERIAL: 17-4 PH, STAINLESS STEEL BAR
PER AMS 5604/5643
GRAIN DIRECTION MUST BE ALONG THE LENGTH OF THE BRACKET
MINIMUM YIELD TENSILE STRENGTH = 100 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 150 ksi
REF. DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3674-043" WITH 0.15 HIGH LETTERS TO A
MAX DEPTH OF 0.010 IN AREA SHOWN.
- 7) IDENTIFICATION: SCRIBE B/N PER QSI 044 6.4
- 8) WEIGHT: 0.26 lbs
- 9) ALL NON DIMENSIONED FEATURES PER CAD FILE "D3674-3RevB.STP/SLDPRT"

VIEW E-E

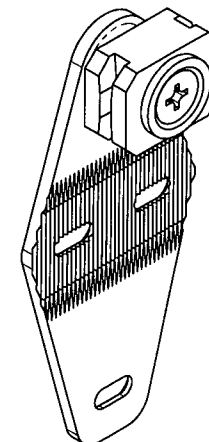
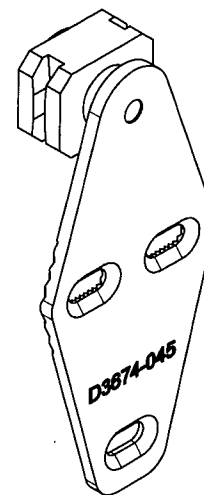
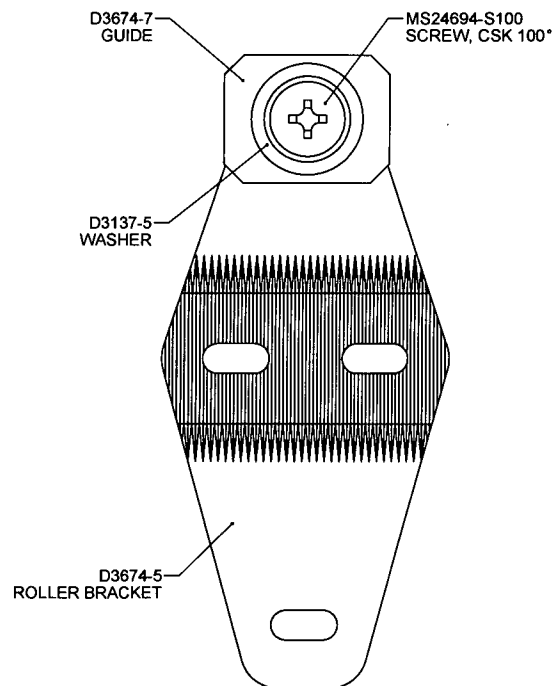


PRELIMINARY ISSUE

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. B4
MFG. APPR.	JLM	ROLLER BRACKET ASSEMBLY	
APPROVED		TITLE	SCALE
DE APPR.		D3674	NTS
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8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
	X	D3674-045	ROLLER BRACKET ASSEMBLY
1	1	D3674-5	ROLLER BRACKET
2	1	D3674-7	GUIDE
3	1	D3137-5	WASHER
4	1	MS24694-S100	SCREW, CSK 100*



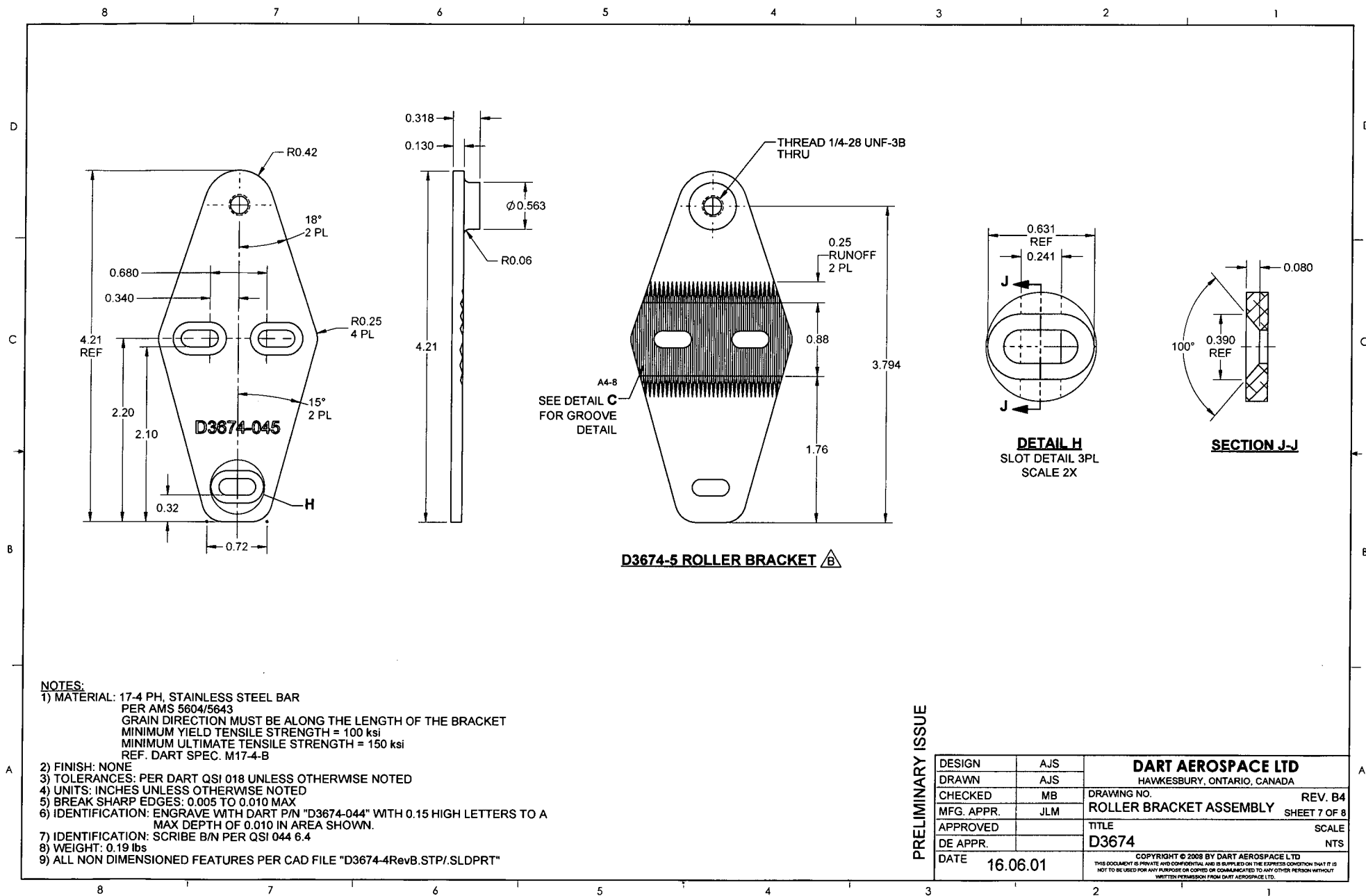
D3674-045 ROLLER BRACKET ASSEMBLY 

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.21 lbs

PRELIMINARY ISSUE

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. B4
MFG. APPR.	JLM	ROLLER BRACKET ASSEMBLY	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		D3674	NTS
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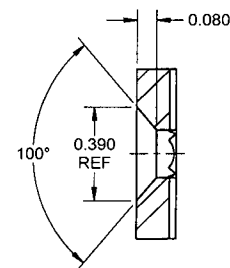
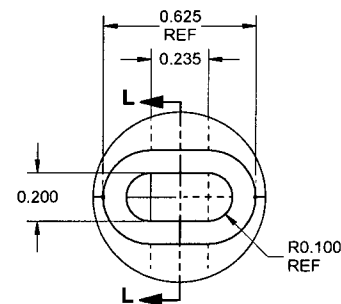
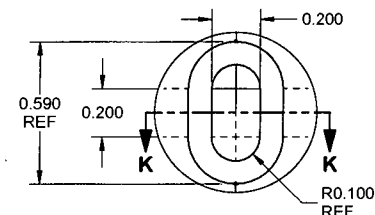
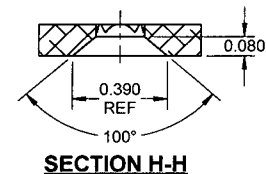
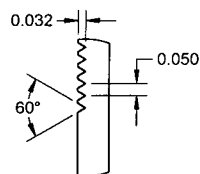
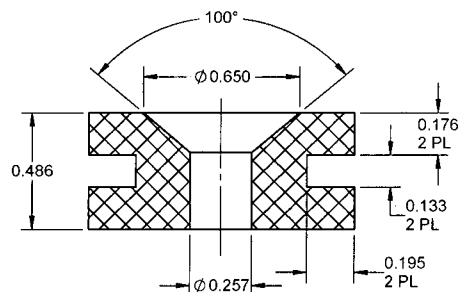
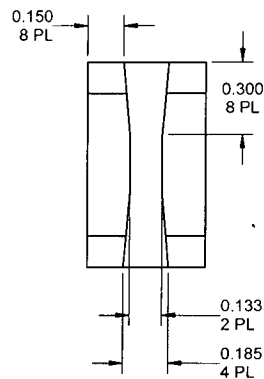
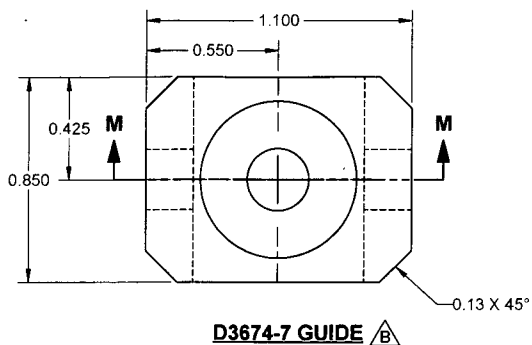
NOTES:

- 1) MATERIAL: 17-4 PH, STAINLESS STEEL BAR
PER AMS 5604/5643
GRAIN DIRECTION MUST BE ALONG THE LENGTH OF THE BRACKET
MINIMUM YIELD TENSILE STRENGTH = 100 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 150 ksi
REF. DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3674-044" WITH 0.15 HIGH LETTERS TO A
MAX DEPTH OF 0.010 IN AREA SHOWN.
- 7) IDENTIFICATION: SCRIBE B/N PER QSI 044 6.4
- 8) WEIGHT: 0.19 lbs
- 9) ALL NON DIMENSIONED FEATURES PER CAD FILE "D3674-4RevB.STP/SLDPRT"

PRELIMINARY ISSUE

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. B4
MFG. APPR.	JLM	ROLLER BRACKET ASSEMBLY	
APPROVED		TITLE	SCALE
DE APPR.		D3674	NTS
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NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL, BAR
REF DART SPEC M-DELRIN-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
- 7) WEIGHT: 0.02 lbs

PRELIMINARY ISSUE

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. B4
MFG. APPR.	JLM	ROLLER BRACKET ASSEMBLY	
APPROVED		TITLE	SCALE
DE APPR.		D3674	NTS
DATE	16.06.01	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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Monday, March 14, 2016 11:23:55 AM

All amounts are calculated in domestic currency.

All Vendors PO ID:PO31123 Receipt Dates from 3/11/2016 to 3/11/2016 All Line Item Types

All Item ID/GL/WOs All Rec. Employees All Currencies

Grouped by Vendor ID

[illegible]

SABIC POLYMERSHAPES

Ship To:
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A 1K7
CANADA

Telephone - 1 (613) 6325200

Bill To:
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A 1K7
Canada

PACKING SLIP

DATE:
10-MAR-16

ORDER:
99012245

PMT TERMS:
CA NET 30

F.O.B.

WAREHOUSE: LONDON ON - SABIC POLYMERSHAPES
1420 Global Drive, Unit 11, London, ON, N6N 0A1, CA

PURCHASE ORDER:
31123

FRT TERMS:
Prepaid Freight

SALES REPRESENTATIVE:
DIXON, WADE

CONTACT NUMBER:
0014005000120

ORDER DATE:
09-MAR-16

DELIVERY NAME
29932104

WAYBILL NUMBER:
330680950764

FREIGHT CARRIER:
PUROLATOR COURIER LTD

FREIGHT CHARGE COMMENT:

LINE	PART NUMBER/ ITEM DESCRIPTION	SHIP DATE	QTY ORDERED	QTY SHIPPED	QTY BACKORD	UOM
1	55200104-C ACT SH 0.750 1.25"x96" BK CP ACETRON GP	10-MAR-2016	1	1	0	EA

SPECIAL INSTRUCTIONS: ACT SH Black .750" Thick x 1.250" wide x 96"

LOT Numbers: total inches (can be two (2) pieces)
(1 Qty)

DAS
9
9-89

RECEIVING IN GOOD CONDITION

Signed:

Date:

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*** End Of Report ***

SABIC POLYMERSHAPES
1420 GLOBAL DRIVE UNIT 11
LONDON, ONTARIO
N6N 0A1
TELEPHONE (519) 681-4500
IN-WATTS (800) 265-6082
FAX (519) 681-2104

DATE: March 9, 2016

MATERIAL CERTIFICATE OF COMPLIANCE

CUSTOMER NAME : DART AREOSPACE LTD

CUSTOMER PURCHASE ORDER # 31123

PRODUCT DESCRIPTION: BLACK ACETAL STRIP .75 X 1.25 X 48- 2 PCS

SABIC SHIPPER NUMBER: 99012245

SABIC ORDER NUMBER: LDN-102132

SPECIFICATION(S) -ASTM-D-4181, POM210

WE CERTIFY THAT THE PRODUCT(S) SHIPPED ON THIS ORDER WILL MEET THE
REQUIREMENTS OF ALL APPLICABLE MILITARY AND COMMERCIAL
SPECIFICATIONS, INCLUDING THOSE LISTED ABOVE.

CERTIFIED BY:



Daryl Parent @ Extension:229

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: MDE/RTU BOTS V1.25

PO / BATCH NO.: H134477 / P031123

DATE: 16-03-14

MATERIAL CERT REC'D: yes
 QUANTITY RECEIVED: 8'
 QUANTITY INSPECTED: 8'
 QUANTITY REJECTED: 0

THICKNESS ORDERED: .750"
 THICKNESS RECEIVED: .750"
 SHEET SIZE ORDERED: U/A
 SHEET SIZE RECEIVED: N/A

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N	
CORRECT FINISH	☒ Y N	
CORROSION	Y ☒ N	
CORRECT GRAIN DIRECTION	☒ Y N	
CORRECT MATERIAL	☒ Y N	
CORRECT THICKNESS	☒ Y N	
PHOTO REQUIRED	Y ☒ N	
CORRECT MATERIAL	☒ Y N	ACETRON GP ACETAL BLACK
CORRECT REF # TO LINK CERT	☒ Y N	P031123
CORRECT MATERIAL IDENTIFICATION	☒ Y N	
CORRECT M# ON THE MATERIAL	☒ Y N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☒ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
TYPE OF MATERIAL SIZE OF TEST SAMPLE HARDNESS / DUROMETER READING	HRC	HRB	DUR A	DUR D	

testers located in the Quality Office

QC18/INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>DAS 9</u> DATE: <u>16-03-14</u>	SIGNED OFF BY: _____ DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO31123

Purchase Order Date 1/25/2016

PO Print Date 1/25/2016

Page Number 2 of 2

Order From :

VC-GEP001

SABIC POLYMERSHAPES
1290 OLD INNES ROAD
UNIT 713
OTTAWA, ON K1B 5M6
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 800 267 1575

Ship To Contact

Ship To Phone

Ship Via: Journey Freight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB FCA (Free Carrier)

3	MDELRLNB0.75X1.250	Delrin Bar	2/3/2016	8.00	\$11.08	\$88.65
			Yes	f		
			2/3/2016			

MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
COLOR: BLACK

4	71401-45	PROCUREMENT QUALITY CLAUSES	1/28/2016	1.00	\$0.00	\$0.00
---	----------	--------------------------------	-----------	------	--------	--------

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A017 RAW MATERIAL IDENTIFICATION (AS
APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A040 NOTIFICATION OF QUALITY ESCAPE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENTS

Line Total: \$88.65

Line Total: \$0.00

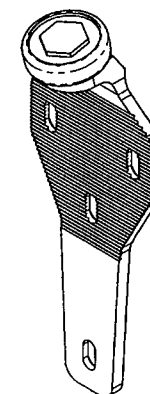
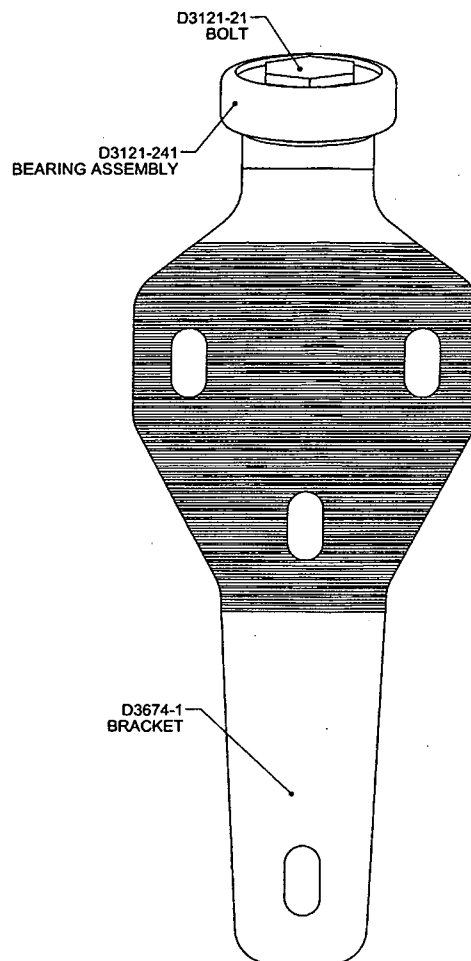
PO Total: \$525.45

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 1/25/2016

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3674-041	ROLLER BRACKET ASSEMBLY
1	1	D3674-1	BRACKET
2	1	D3121-21	BOLT
3	1	D3121-241	BEARING ASSEMBLY



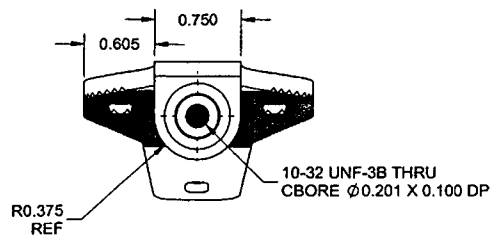
NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.31 lbs
 8) TORQUE D3121-21 BOLT 15-25 in lbs (1.7-2.8 Nm)

D3674-041 ROLLER BRACKET ASSEMBLY

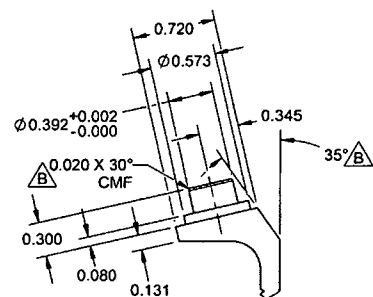
RELEASED
 2016-07-26
 EWL 46-531

APPROVED

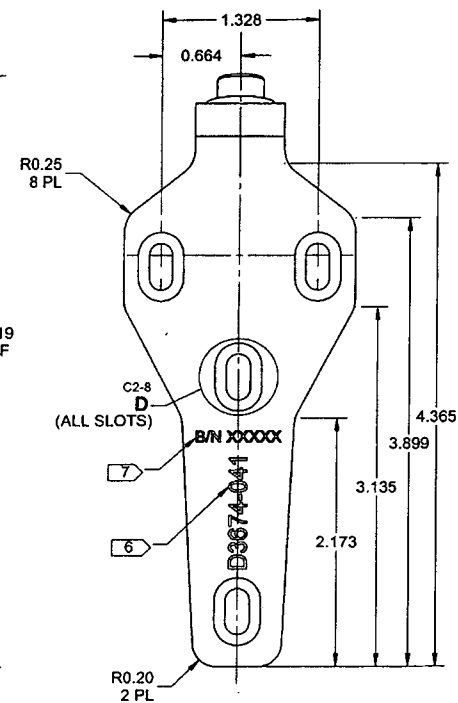
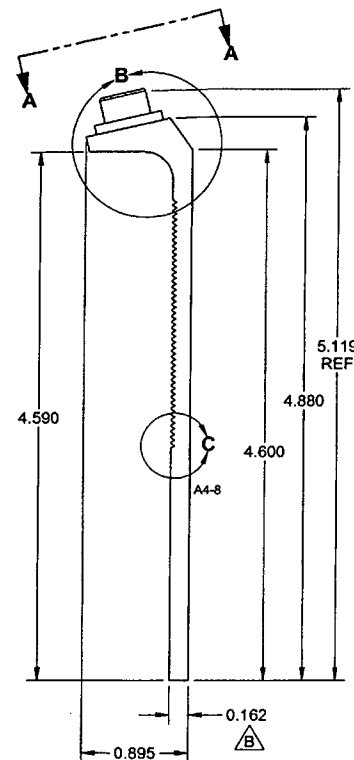
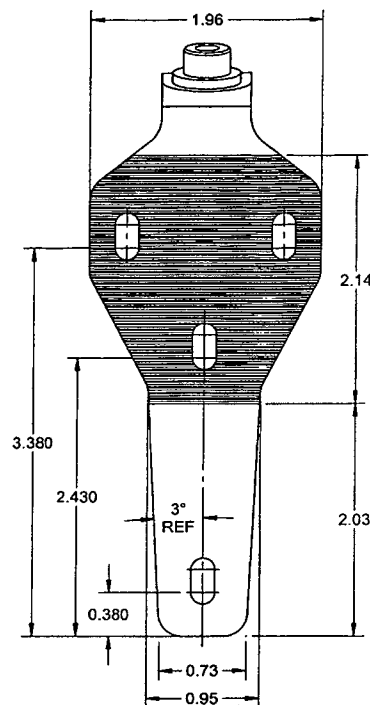
B	GENERAL UPDATE TO CURRENT STANDARDS. ADD -3/5/-7/-9/-043/-044/-045, FOR BELL COMPOSITE DOOR. B3-2 DIM 0.162 WAS 0.130. B7-2 35" WAS 30". SHT 2 UPDATE NOTE 6. SEE PAR 16-501.		AJS	16.06.01
A	NEW ISSUE		AJS	08.03.28
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED	MB	DRAWING NO.	REV. B	
MFG. APPR.	RQ	D3674	SHEET 1 OF 8	
APPROVED	WM	TITLE	SCALE	
DE APPR.	DS	ROLLER BRACKET ASSEMBLY	NTS	
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VIEW A-A



DETAIL B



D3674-1 BRACKET

NOTES:

- 1) MATERIAL: 17-4 PH, STAINLESS STEEL BAR
PER AMS 5604/5643
GRAIN DIRECTION MUST BE ALONG THE LENGTH OF THE BRACKET
MINIMUM YIELD TENSILE STRENGTH = 100 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 150 ksi
REF. DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3674-041" WITH 0.15 HIGH LETTERS TO A
MAX DEPTH OF 0.010 IN AREA SHOWN.
- 7) IDENTIFICATION: SCRIBE B/N PER QSI 044 6.4
- 8) WEIGHT: 0.27 lbs
- 9) BASIC PROFILE OF D3674-1 BRACKET TAKEN FROM D3121-141 REF.
- 10) ALL NON DIMENSIONED FEATURES PER CAD FILE "D3674-1REV.B.STP/SLDPRT"

RELEASED
2016-07-26

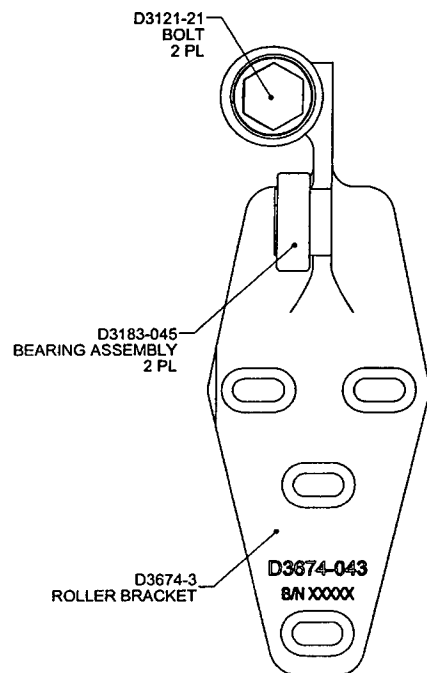
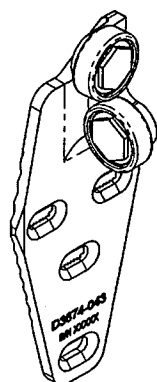
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DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED	MB	DRAWING NO. D3674
MFG. APPR.	RQ	REV. B SHEET 2 OF 8
APPROVED	WM	TITLE
DE APPR.	DS	SCALE
DATE	16.06.01	ROLLER BRACKET ASSEMBLY NTS

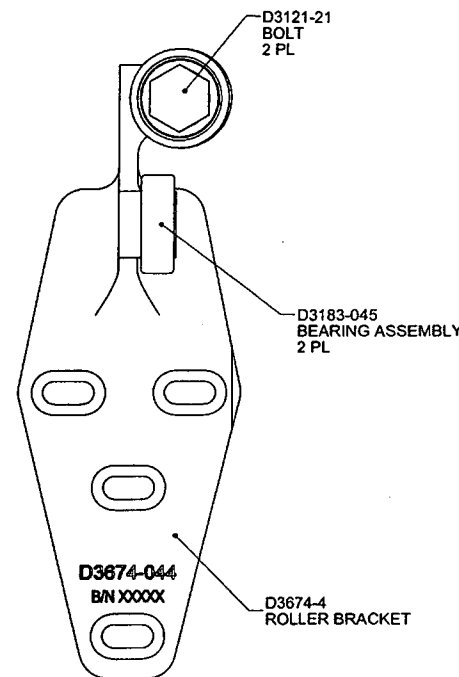
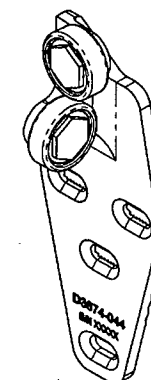
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ITEM	QTY -043	P/N	DESCRIPTION
	X	D3674-043	ROLLER BRACKET ASSEMBLY
1	1	D3674-3	ROLLER BRACKET
2	2	D3183-045	BEARING ASSEMBLY
3	2	D3121-21	BOLT

ITEM	QTY -044	P/N	DESCRIPTION
	X	D3674-044	ROLLER BRACKET ASSEMBLY
1	1	D3674-4	ROLLER BRACKET
2	2	D3183-045	BEARING ASSEMBLY
3	2	D3121-21	BOLT



D3674-043 ROLLER BRACKET ASSEMBLY



D3674-044 ROLLER BRACKET ASSEMBLY

NOTES:

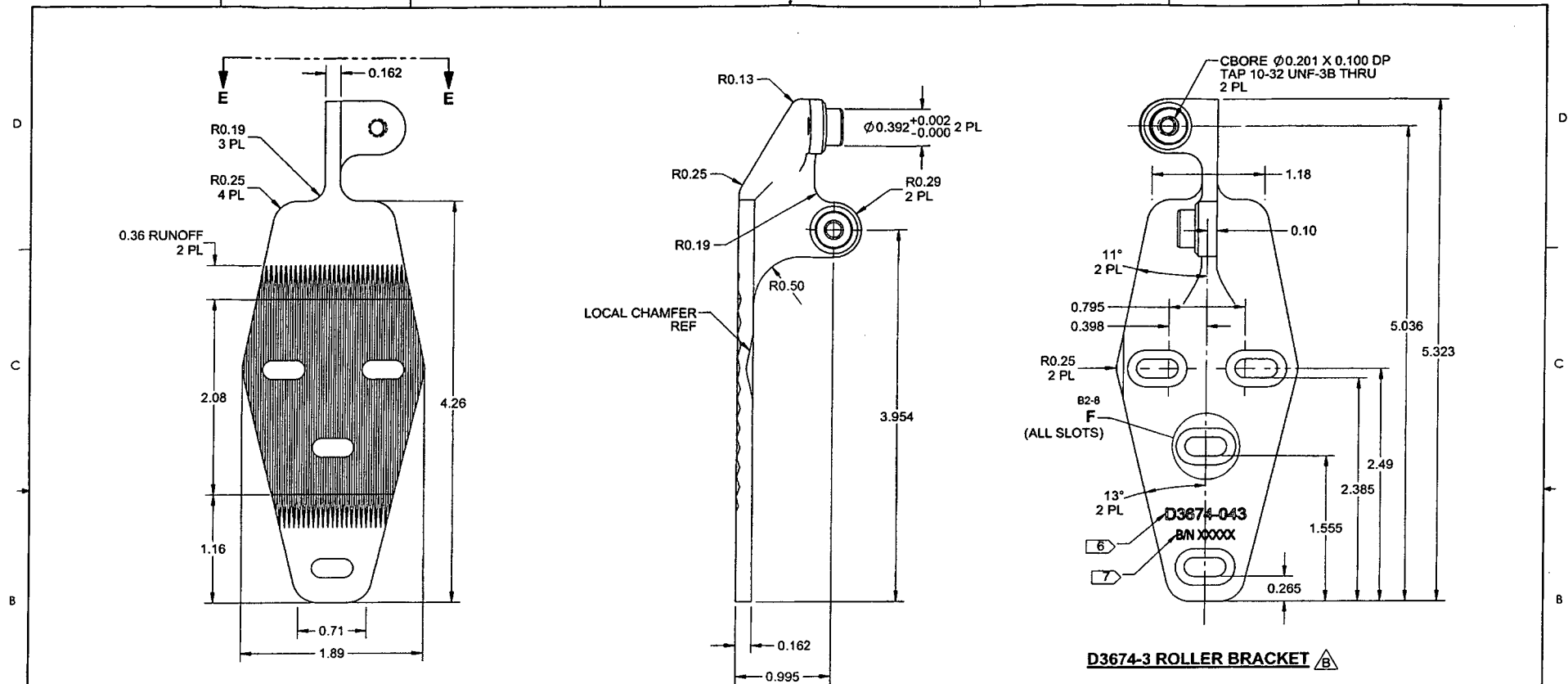
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.37 lbs
- 8) TORQUE D3121-21 BOLT 15-25 in lbs (1.7-2.8 Nm)

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	MB	DRAWING NO.	REV. B
MFG. APPR.	RQ	D3674	SHEET 3 OF 8
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	ROLLER BRACKET ASSEMBLY	NTS
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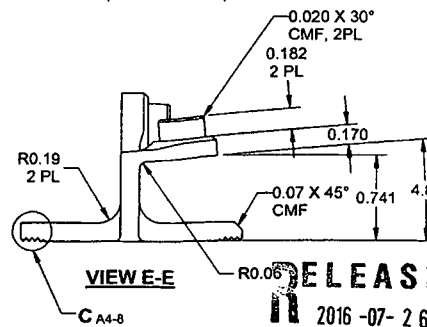
APPROVED

8 7 6 5 4 3 2 1



NOTES:

- 1) MATERIAL: 17-4 PH, STAINLESS STEEL BAR
PER AMS 5604/5643
GRAIN DIRECTION MUST BE ALONG THE LENGTH OF THE BRACKET
MINIMUM YIELD TENSILE STRENGTH = 100 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 150 ksi
REF. DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3674-043" WITH 0.15 HIGH LETTERS TO A
MAX DEPTH OF 0.010 IN AREA SHOWN.
- 7) IDENTIFICATION: SCRIBE B/N PER QSI 044 6.4
- 8) WEIGHT: 0.31 lbs
- 9) ALL NON DIMENSIONED FEATURES PER CAD FILE "D3674-3RevB.STP/SLDPRT"



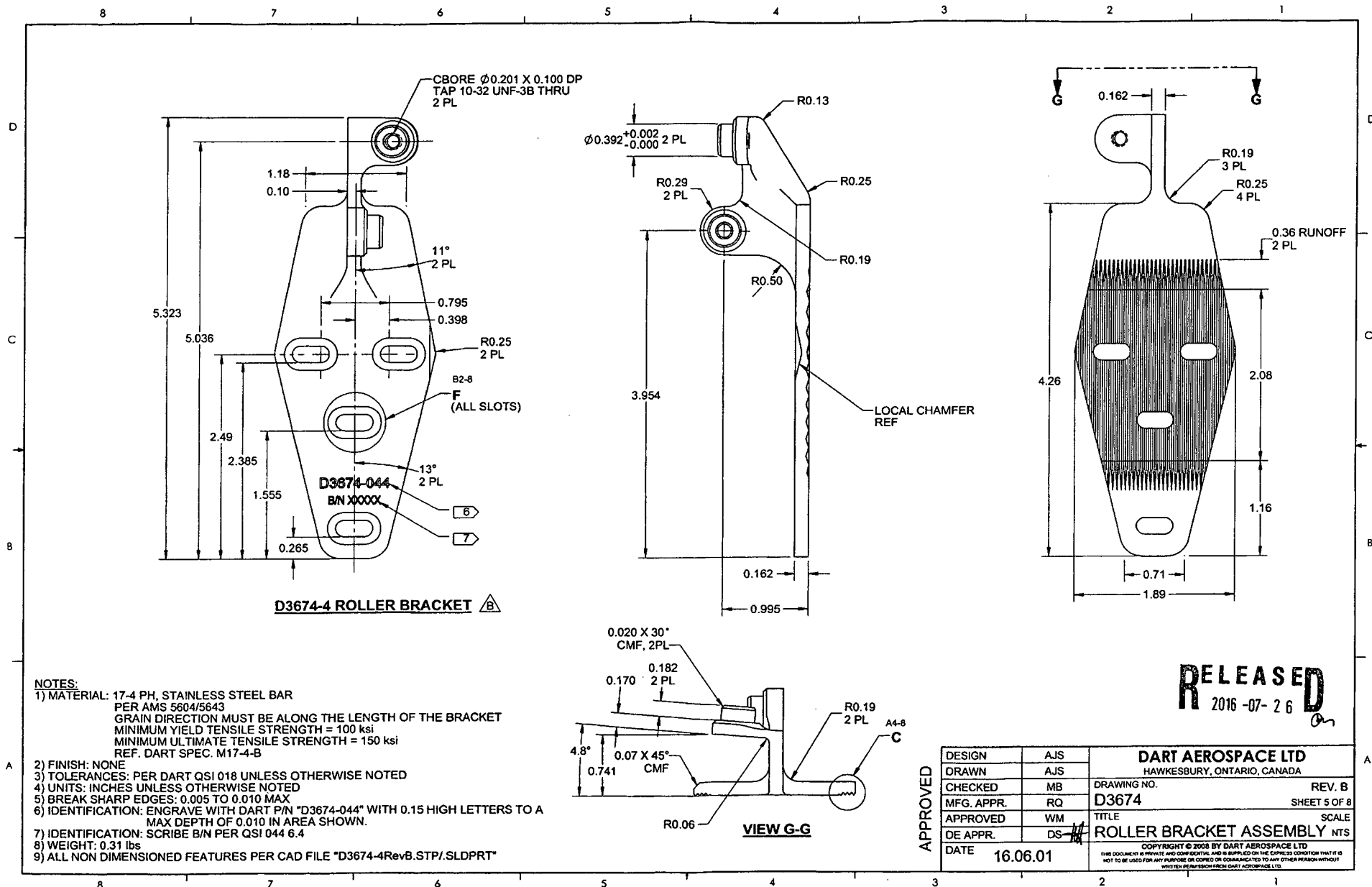
D3674-3 ROLLER BRACKET

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESSBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. B
MFG. APPR.	RQ	D3674	SHEET 4 OF 8
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	ROLLER BRACKET ASSEMBLY NTS	
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2016-07-26

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8 7 6 5 4 3 2 1



ITEM	QTY	P/N	DESCRIPTION
	X	D3674-045	ROLLER BRACKET ASSEMBLY
1	1	D3674-5	ROLLER BRACKET
2	1	D3674-7	GUIDE
3	1	D3137-5	WASHER
4	1	MS24694-S100	SCREW, CSK 100*

D3674-5
ROLLER BRACKET

D3674-045 ROLLER BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH :NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.26 lbs
- 8) TORQUE MS24694-S100 BOLT 50-70 in lbs (5.6-7.9 Nm)

D3674-7
GUIDE

D3137-5
WASHER

MS24694-S100
SCREW, CSK 100*

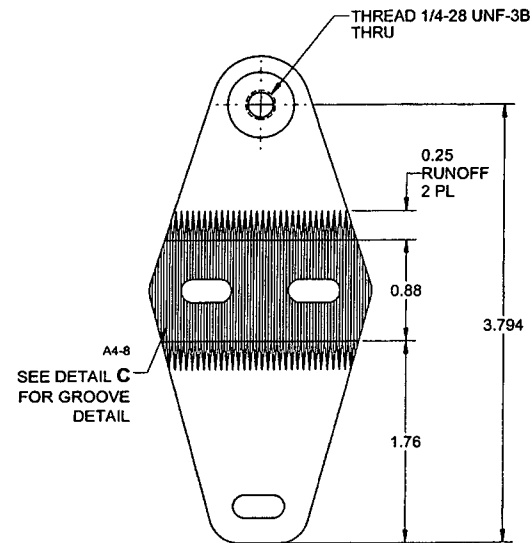
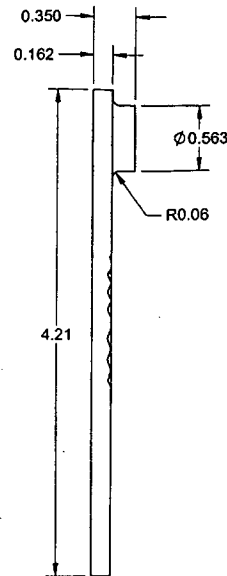
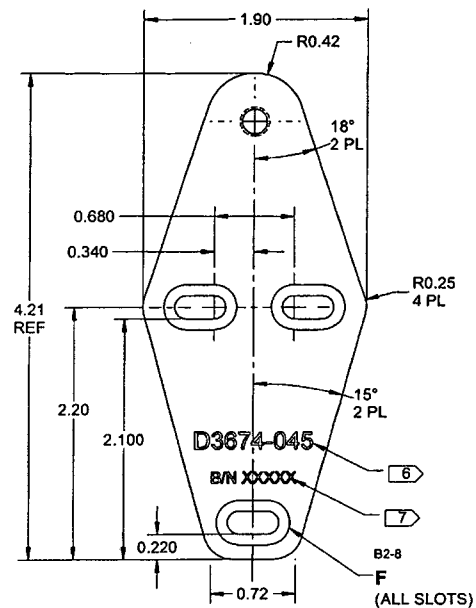
D3674-045

B/N XXXXX

APPROVED

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	MB	DRAWING NO.	REV. B
MFG. APPR.	RQ	D3674	SHEET 6 OF 8
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	ROLLER BRACKET ASSEMBLY	NTS
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2016-07-26



D3674-5 ROLLER BRACKET ^B

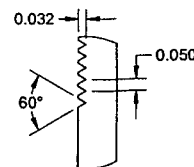
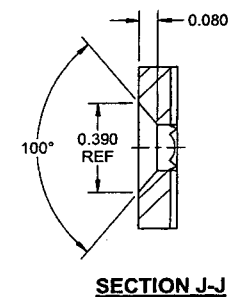
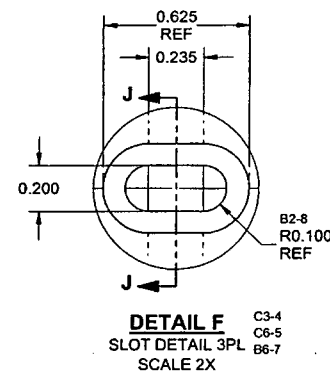
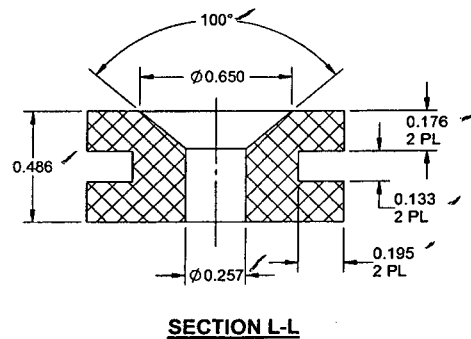
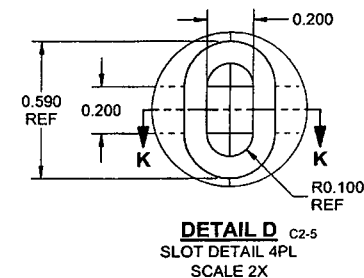
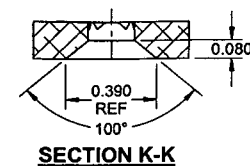
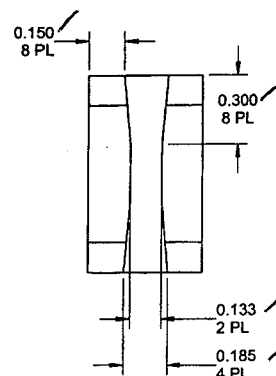
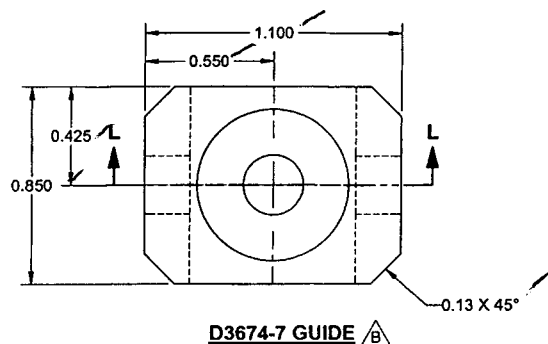
NOTES:

- 1) MATERIAL: 17-4 PH, STAINLESS STEEL BAR
PER AMS 5604/5643
GRAIN DIRECTION MUST BE ALONG THE LENGTH OF THE BRACKET
MINIMUM YIELD TENSILE STRENGTH = 100 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 150 ksi
REF. DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3674-045" WITH 0.15 HIGH LETTERS TO A
MAX DEPTH OF 0.010 IN AREA SHOWN.
- 7) IDENTIFICATION: SCRIBE B/N PER QSI 044 6.4
- 8) WEIGHT: 0.24 lbs
- 9) ALL NON DIMENSIONED FEATURES PER CAD FILE "D3674-5RevB.STP/SLDPRT"

RELEASED
2016-07-26

APPROVED

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. B
MFG. APPR.	RQ	D3674	SHEET 7 OF 8
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	ROLLER BRACKET ASSEMBLY	NTS
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- NOTES:**
- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL, BAR
REF DART SPEC M-DELRIN-B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
 - 7) WEIGHT: 0.02 lbs

DETAIL C C3-2
A5-4
A3-5
C3-7

RELEASED
2016-07-26

APPROVED

DESIGN	AJS
DRAWN	AJS
CHECKED	MB
MFG. APPR.	RQ
APPROVED	WM
DE APPR.	DS
DATE	16.06.01

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3674	REV. B SHEET 8 OF 8
TITLE ROLLER BRACKET ASSEMBLY	SCALE NTS
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